

Date: Monday, 10/30/2006 4:14:55 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEB ASSEMBLY  
 Job Number : 29225  
 Estimate Number : 10194  
 P.O. Number : N/A Part Number : D2174041  
 This Issue : 10/30/2006 S.O. No. : N/A Drawing Number : D2174-041 UNDER REV REV E LE 06.10.31  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : UNDER REVIEW REV E  
 Previous Run : 26017 Material : N/A  
 Written By : Due Date : 11/24/2006 Qty: 14 Um: Each  
 Checked & Approved By :  
 Comment : Est: D 04.06.10 Reformat; Changed Step 2 KJ/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D21741 Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 14.0000 Each(s)  
 Web

Qty	Part Number	Description	Batch
1	D2174-1	Web	B20027

2.0 D21751 Angle LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 14.0000 Each(s)  
 Angle LH

Qty	Part Number	Description	Batch
1	D2175-1	Angle	B24495

3.0 D21752 Angle RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 14.0000 Each(s)  
 Angle RH

Qty	Part Number	Description	Batch
1	D2175-2	Angle	B24496

4.0 MS20470AD46 Rivet, Universal Head



Comment: Qty.: 322.0000 Each(s)/Unit Total : 322.0000 Each(s)  
 Rivet, Universal Head

Qty	Part Number	Description	Batch
19	MS20470AD4-6	Rivet	M18615

4 ANS26C832R14 Screw M9216

4 AN960JDB Washer M102455

4 MS21042208 Nut M101438


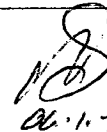


8.2 INSPECT WORK.

06/11/2006 Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA:    Date: 06/11/30  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/11/22	5	<del>Open hole at</del> <del>Ø.172</del> hole to small Ø.130		Open hole at Ø.172	SB 06/11/23	 06.11.23	 06/11/23	 06.11.23

NOTE: Date & initial all entries

Date: Monday, 10/30/2006 4:14:56 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB ASSEMBLY

Job Number: 29225

Part Number: D2174041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg D2174-041

2- Identify as D2174-041

SB 06/11/23 20

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/14/23 (20)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL 06/11/24 (20)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06/14/22 (20)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57220

06/14/27 (20)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/11/30 (20)

Job Completion



06/11/28

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

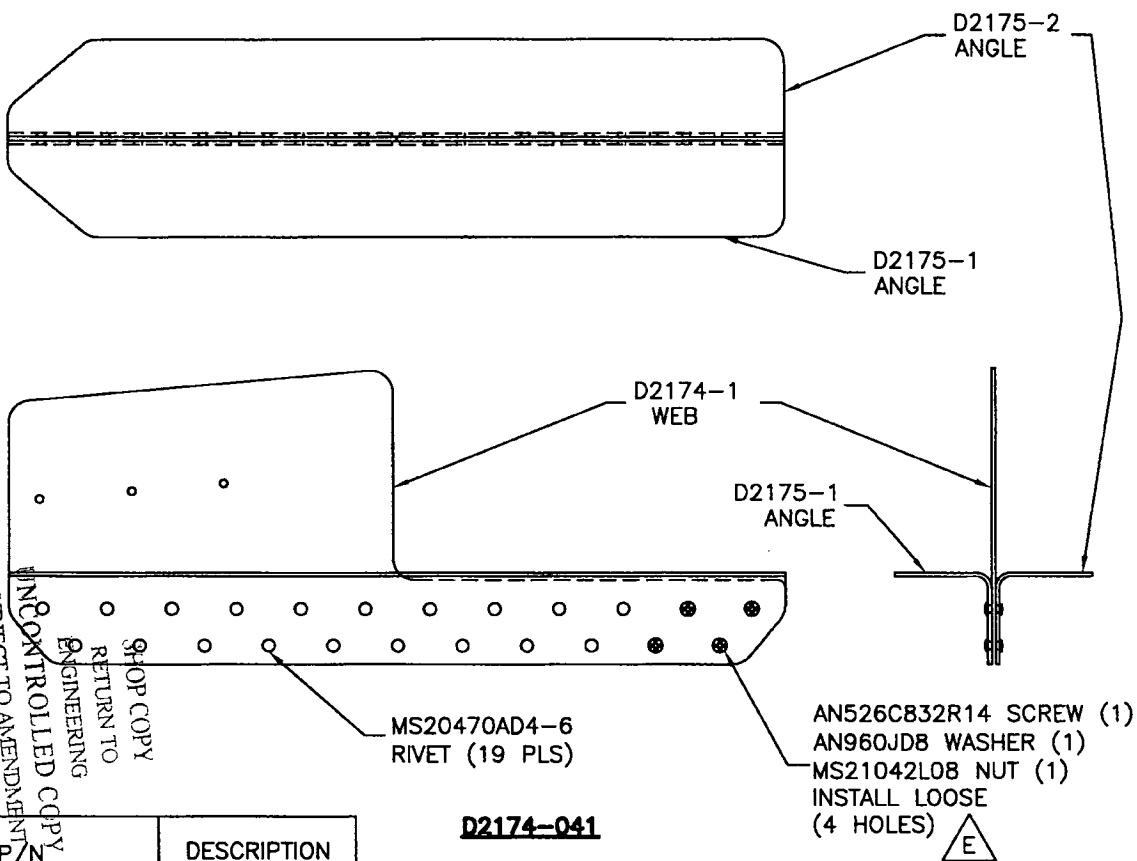
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. E
RF	CE	HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED PH	DRAWING NO. D2174	SHEET 1 OF 2
DATE 06.09.25		TITLE WEB ASSEMBLY	SCALE 1:3
A	95.10.25	NEW ISSUE	
B	96.01.18	RE-DRAWN	
C	00.09.11	UPDATE FINISH SPEC.	
D	04.06.03	RE-DESIGN	
E	06.09.25	INC 4 HOLES TO Ø0.172; CHG HARDWARE	



**D2174-041**

QTY	P/N	DESCRIPTION
X	D2174-041	WEB ASSEMBLY
1	D2174-1	WEB
1	D2175-2	ANGLE
1	D2175-1	ANGLE
4	AN526C832R14	SCREW
4	AN960JD8	WASHER
4	MS21042L08	NUT
19	MS20470AD4-6	RIVET

**NOTES:**

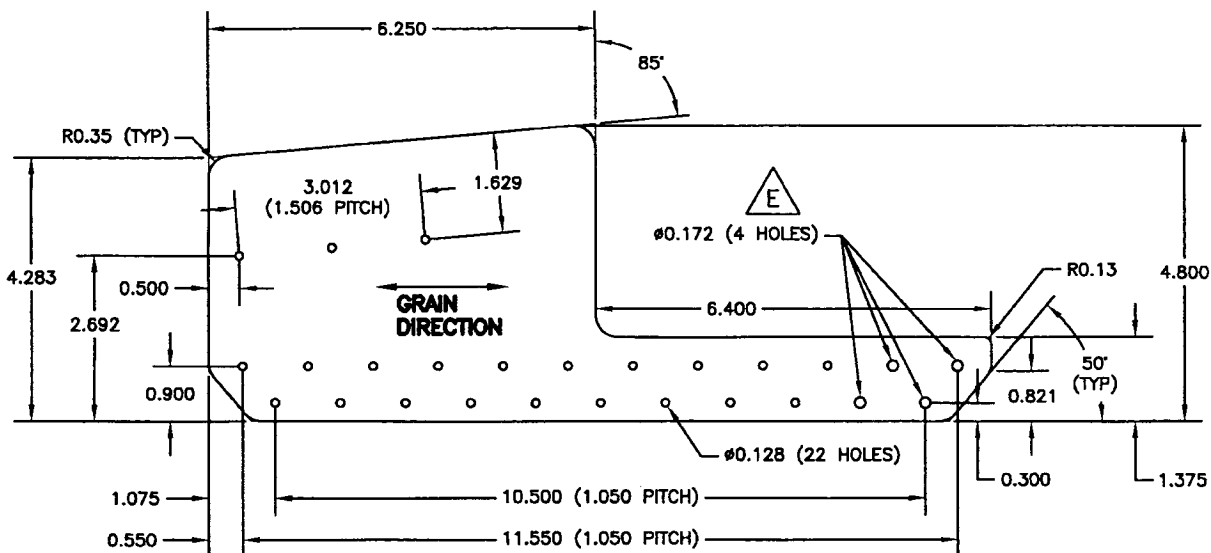
- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) IDENTIFY WITH P/N D2174-041 USING FIND POINT PERMANENT INK MARKER.

WORK ORDER  
NO. 24225  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

RELEASED  
06.10.13



DESIGN	DRAWN BY	DART AEROSPACE LTD
RF	CE	HAWKESBURY, ONTARIO, CANADA
CHECKED PH	APPROVED [Signature]	REV. E
DATE 06.09.25	TITLE WEB	DRAWING NO. D2174
		SHEET 2 OF 2
		SCALE 1:3



D2174-1

NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-200/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSION ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 29225

RELEASED  
06.10.23